

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003521**Date Inspected:** 15-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Wei Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Assembly Bay # 2

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. This QA inspector performed UT on deck panel DP109-002, weld 2 scanned 13 locations with 2 indications, weld 3 scanned 13 locations with 2 indications, weld 4 scanned 13 locations with 6 indications. A total of 39 tack welds were tested with 10 indications found. This QA inspector was informed by the task leader that a TL-6027 was not required at this time.

Sub Assembly Bay # 7

QA performed 10% verification Magnetic particle Testing (MT) on the following OBG longitudinal diaphragm fillet welds, LD001-008-011, LD021-002-0011, LD003-020-011, LD003-017-011, LD004-018-011, LD004-019-011, LD013-002-011, LD002-008-011 and LD004-020-011. ZPMC notification of NDT listed welds 001 through 012. Only testing of weld 011 was possible due to the plates positioning. All of the welds that were

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

examined appeared to comply with AWS D1.5 2002 and the contract documents. See MT report TL-6028, generated on this date for further information.

Summary of Conversations:

No relevant conversations between Caltrans QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138 1694 2685, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
